

Work Order ID 51710



Page 1

August 28, 2009 8:21:35 AM

Item ID: D2282-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: T Assembly

Start Date: 8/31/09 Start Qty: 50.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 50.00

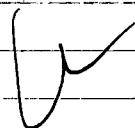


Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Memo	0.00	0.00	0.00	0.00	0.00	0.00	0.00
100			0.00						
		Large Fab							
Large Fab			0.00						
Large Fab		I-Weld as per D2282-041 'T' Handle Assembly <input type="checkbox"/> Grind chamfers and ensure full penetration as per dwg D2282 <input type="checkbox"/> *****brush weld right after welding, to take color off ***** <input type="checkbox"/> A/RER316L SS Filling Rod 110910	0.00						
110		QC9- Inspect visual per QSI004- Fusion Welds	0.00						
		Memo	0.00						
QC			0.00						
Quality Control			0.00						
120			0.00						
		Small Fab							
Small Fab		Memo	0.00						
Small Fab		Tumble	0.00						

M109213

8/09/09/09

50x

PD 09.10.09.

RS 9-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51710

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August 28, 2009 8:21:35 AM

Item ID: D2282-041

Accept



Setup Start



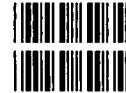
Revision ID: E

Stop



Item Name: T Assembly

Start Date: 8/31/09 Start Qty: 50.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

130



QC

Quality Control

**Operation
Description**

QC5- Inspect part completeness to step on W/O

**Set Up/
Run Hours**

0.00

**Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

→ S or 10/13

*Counted
(X50)*

CS/10/13 (50)

140



Packaging

Packaging

Identify as per dwg & Stock Location: *ST261* 0.00

0.00

Memo

0.00

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/10/14 HJ

*MF
09-10-14*

Picklist Print

Page 1

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Work Order ID: 51710



Parent Item: D2282-041RevE



Parent Item Name: T Assembly

Start Date: 8/31/09

Required Date: 9/04/09

Comments:

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2282-3RevE 		Manufactured	No			100	Each	0.0000	50.0000		351725 → 50x	MM 09/10/09
Tube 		Manufactured	No			100	Each	34.0000	50.0000		348281 → 34x	MM 09/10/09
D2282-5RevE 		Manufactured	No			100	Each	34.0000	50.0000		351726 → 16x	MM 09/10/09
							<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
							Location					
				Main Warehouse								
							ST	34				
							48281	34				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

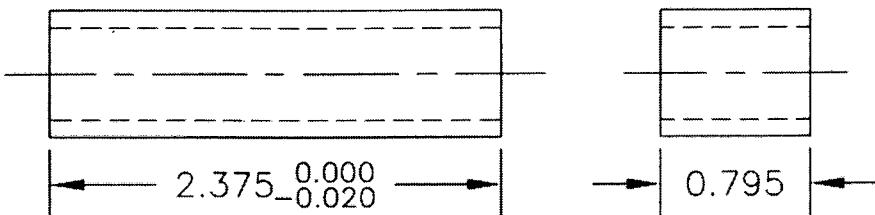
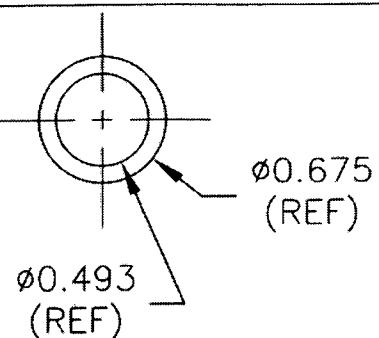
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE:-Date & initial all entries

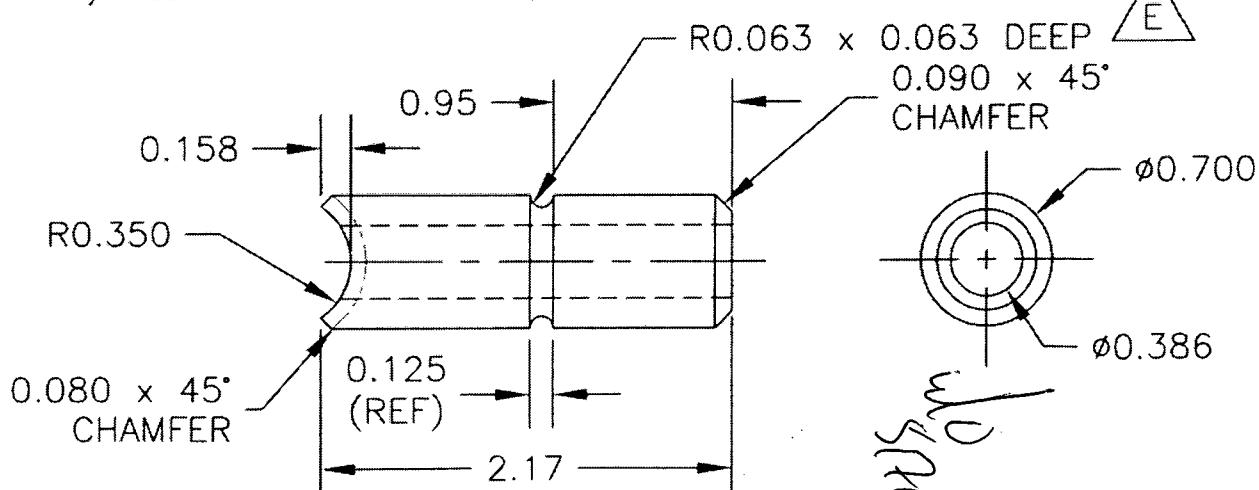
DART

DESIGN BW	DRAWN BY <i>FJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>100%</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
Revised
BS/09/16

**D2282-3****D****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D****D2282-5****E****D2282-5 STEM:**

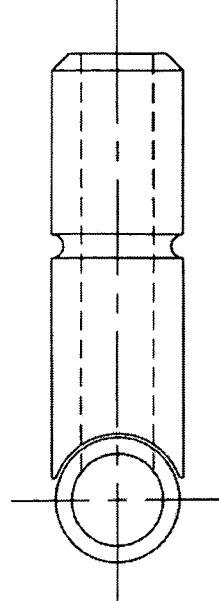
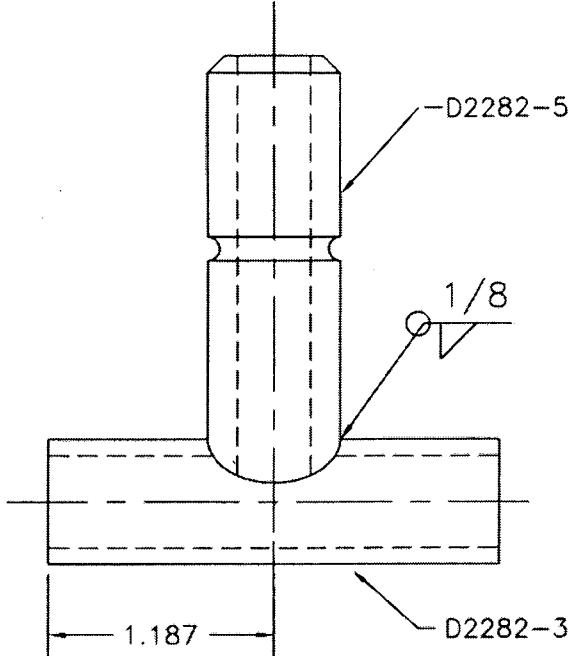
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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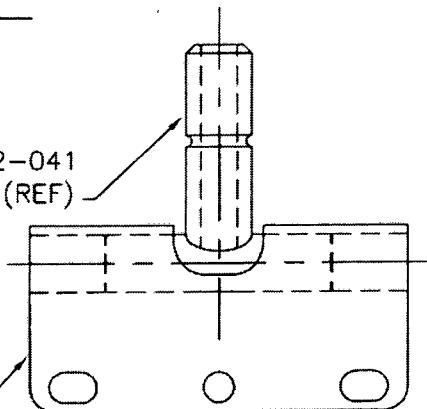
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DART

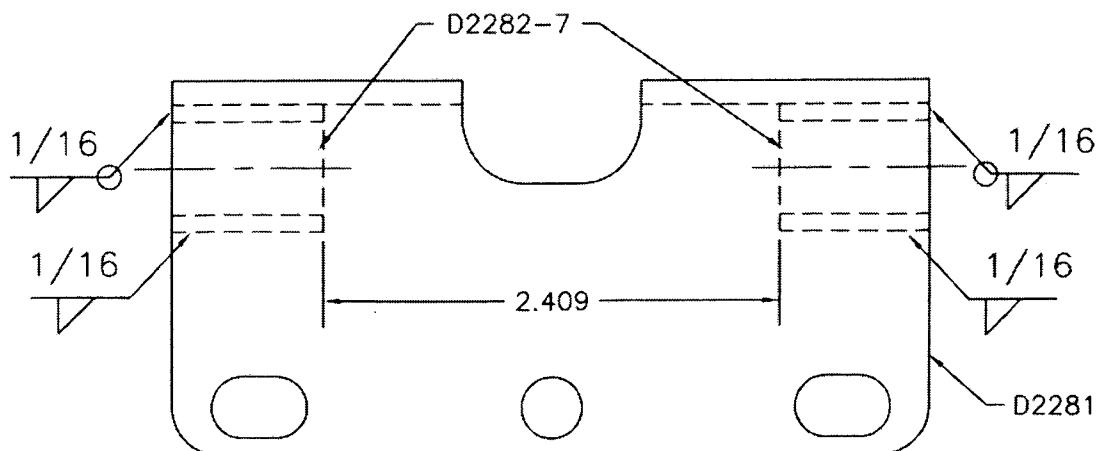
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CHECKED <i>IP</i>	APPROVED <i>MM</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



RE ISSUED
05/09/16



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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